

Work Order ID 69698

Tuesday, May 17, 2011 7:33:31 AM



Page 1

Item ID:	D2571	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, Fwd Out 205					
Start Date:	5/17/2011	Start Qty:	12.00	Cust Item ID:		
Required Date:	6/6/2011	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/05/17</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2571	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	Memo	0.00						
HAAS CNC vertical machine #1	Program Batch No. <u>69698</u> Double check by: <u>SL 11/06/15</u> <u>45</u> <input type="checkbox"/> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets <input type="checkbox"/> 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets <input type="checkbox"/> 3-Machine Step No 3 per Folio FA051 and inspect								

110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv	Memo	0.00						
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572 <u>SL 11/06/15</u>								

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control	<u>SL 11/06/15</u>								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 5/17/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

B.A 11/06/15

4

0



QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

4 0 11/06/15



HandFinish

Memo

0.00

Hand Finishing

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

4x 0 m 11/06/15



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:00

10:30

M116964

3200F

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Item ID: D2571

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Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 5/17/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 \$ 11/06/15

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

11/6/15 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15

11-06-15 (4)

Dart Aerospace Ltd

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Picklist Print

Tuesday, May 17, 2011 7:33:29 AM

Page 1

Work Order ID: 69698



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 5/17/2011

Required Date: 6/6/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	39.0000	1	12			
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21 11/06/14

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

9

66967

9

4

MAT045

30

65383

13

65954

17

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	69698
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.501	.500	.496	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.502	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.570	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.251	.251	.251		
S	0.115	0.135		.127	.129	.127	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.241	.240	.240		
W	0.115	0.135		.124	.124	.128	.124		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.364	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.249	.250	.250		
AE	1.375	1.395		1.389	1.388	1.388	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.250	.251		
AI	2.000	2.020		2.004	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	11/06/14

Audited by:	R.A
Date:	11/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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05-12-06 

MATERIAL: 7075-T7351 (00-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

$$\triangle E$$

Technical drawing of a mechanical part, showing a cross-section (VIEW B-B) and a top view. The cross-section shows a profile with a central rectangular feature (1.73 x 0.20) and a triangular feature (2). The top view shows a rectangular part with a central slot (3.500 ± 0.005) and four circular features (1.750 ± 0.005). The part has a total width of 8.000. Surface finish symbols are present on the top and bottom surfaces.

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MORRISBURG, ONTARIO, CANADA	
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE SCALE 2:3	

W/O:		WORK ORDER CHANGES					
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